Work Order ID 59475 Friday, June 04, 2010 2:45:55 PM						A A			Page 1
Item ID: Revision ID:	D3999-043			Accept			Setup		
Item Name: Start Date: Required Date: Reference:	Baffle Assemble 6/4/2010 6/10/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:		Stop	
Approvals:	Process Pla	in:		Tooling: SPC (Y/N):		ate:	Run	Start Stop	T (MATA) AN ANTI MATA (MATA)
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Re Qty Qt		Reject Insp. Number Stamp
Draw Nbr	Rev	ision Nbr							
D3999	A								
100 Waterjet		Memo		0.00			18 (0~	69	
FLOW CNC Waterj	iet	1-Cut as pe							$\bigcirc$
6061.0	63	Dwg Rev:_ Prog Rev:_ 2-Deburr if	<u>Α</u>		×				
110 °		QC2- Inspect parts off r	nachine FAI/FAIB	0.00					
QC Quality Control		Memo		0.00			HB10-6-	9	

#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP** PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval** Approval Sign & Initial **Action Description** Section A Section C QC Inspector Chief Eng Chief Eng Date Chief Eng

#### Work Order ID 59475

Friday, June 04, 2010 2:45:55 PM



Page 2

Item ID:

D3999-043

Accept

Setup Start

Stop



Revision ID:

Item Name: Baffle Assembly, Fwd

**Start Date:** 

6/4/2010

Start Oty: 1.00

**Required Date: 6/10/2010** Req'd Otv: 1.00

**Cust Item ID:** Customer:

Reference:

Approvals:

Process Plan:

Date: Date: \_\_\_\_\_ Tooling:

SPC (Y/N):

Date: Date:

**Tool ID** 

Run

Start



Sequence ID/ Work Center ID

120

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00

Stop



Tool # Plan

Code

Accept Qty

Reject Qty -

Reject Number Stamp

Insp.

**Quality Control** 

Bend as per dwg

0.00 SB color 28

130

Brake NC

Brake NC

Memo

Bend D3999-3 as per Dwg

180

Small Fab Small Fab

Memo

Assemble as per dwg

0.00

0.00

£510/06/30 Q

Dart	Aer	osp	ace	Ltd

W/O:			W	ORK ORDER CHA	NGES					<u> </u>
DATE	STEP	TEP PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
			Disposition: QA: N/C Closed: ORK ORDER NON-CONFORMANCE (NCR)					Date:		
	T					(11011)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Description Chief Eng	Section B	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector

### Work Order ID 59475

Friday, June 04, 2010 2:45:55 PM



Page 3

Item ID:

D3999-043

Accept

Setup Start

**Revision ID:** 

Item Name: Baffle Assembly, Fwd

**Required Date: 6/10/2010** 

Start Date:

6/4/2010

Start Otv: 1.00

Reg'd Oty: 1.00



Date: \_\_\_\_\_

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

OC:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Stop

Start

Stop



Sequence ID/

**Work Center ID** 

190

**Quality Control** 

Operation Description

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: 13

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Run

Reject Oty

Reject Number

Insp. Stamp

Memo

200

Packaging

Packaging

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aeros	pace Ltd
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W/O:	,		W	ORK ORDER CHANG	ES						
DATE STEP		PRO	PROCEDURE CHANGE By Da					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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<del></del>											
Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Ye	es No	DQA:		Date:		
			Disposition: Q/						I I		
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (N	CR)					
DATE	STEP Description of NC		Corrective Action Section B			Verifica		ion	Approval	Approval	
	0,2,	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section C		Chief Eng	QC Inspector	
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# **Picklist Print**

Friday, June 04, 2010 2:46:00 PM

Work Order ID: 59475

Parent Item:

D3999-043

Parent Item Name:

Baffle Assembly, Fwd

**Comments:** 

IPP rev A 09.12.16 new issue Prelim EC verified by:DD

10.05.10 ecn 10-562 EC verified by:DD

**Start Date:** 6/4/2010

Required Date: 6/10/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Item ID M6061T6S.063

Replacement Mfg/ Purch Purchased

Manufactured

Purchased

Primary Location Item No

No

No

Last Location Route Seq ID 100

180

180

Unit of Qty on Measure Hand sf 130,7000

Qty per Kit Total

Otv 2.66 2.8

Issued

\$10-69

Qty

Date Status Issued

Page 1

6061-T6 .063 Sheet

D3999-5

Angle

Location

MAT21

113608

Loc Qty 130.7

130.7

0.0000

Loc Code

Each

Each

1,860.000

Rivet, Universal Head

MS20470AD4-4

Location Loc Qty Loc Code ST319 122 112314 30 113368 92 ST321 1738 114761 1738

#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval **Approval** DATE STEP PROCEDURE CHANGE Bv Qtv Date Chief Eng / QC Inspector Prod Mar Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_ Date: \_\_\_ Resolution: \_\_\_\_\_ Disposition: \_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP Action Description** Sign & Initial Section A QC Inspector Section C Chief Eng Chief Eng Chief Eng Date

DART AEROSPACE LTD	Work Order:	59475
Description: BATTE ASSEMBLY FULD	Part Number:	D3999-043
Inspection Dwg: 0399-3 Rev: 14		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X F	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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\$ ,768 \$ 3.35	100 510. +	3,348	<b>b</b>			
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60,1	4030	(60)	79-2			
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10.77	4 .00	10,761	य			
13.02	4 .030	13.02	4			
20,10	4 .30	20.10	\ <del>\</del>			
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75,44		25.44	*	<u> </u>		
26.15	4 .30	96.15	.hr	<u> </u>		
1.46	4030	1,46	14			
2.43	4 .030	2.43	<u> -دلا</u>			
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5,77	4030	5.772	ч	-	<u> </u>	Ši <sub>2</sub>
7.21	4 .00	7.31	<del>*</del>	-		279
9.08	7 .30	9.083	<del>  Y-</del>			
9.93	7 30	9.928	<del>}</del>	-		
08,	7/030	008,	يع		<u> </u>	

Measured by:	r de la companya de l	Audited by:	Prototype Approval:	N/A
Date:	10-6-9	Date: 10/66/10	Date:	N/A

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- 1	Rev	Date	Now legge KJ/JLM	1 . 1
	Α .		New Issue Rosella	<del></del> _

DART AEROSPACE LTD	Work Order:	59478
Description: BALLIE ASSEMBLY FWD	Part Number:	D3949-043
Inspection Dwg:D3999-3 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

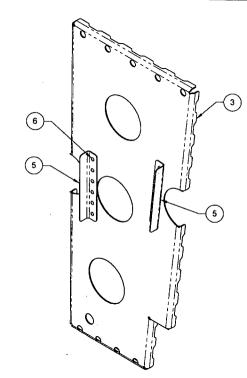
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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4.71	4 30	4.714	Z			
5,77	4 .030	215,2	*			
7.46	4 030	7,462	*			
9.91	1/2 .000	9.908	4			
10:21	4 030	10.304	*			
12.96	4 030	12.96	×			
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Measured by: 12	Audited by:	Prototype Approval:	N/A
Date: 10-6-9	Date: 10/66/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Kev	Date		KJ/JLM	
_ A		New Issue		• •

				o ,
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
X		D3999-041	BAFFLE ASSEMBLY, AFT	JCA-M47-1-02
	х	D3999-043	BAFFLE ASSEMBLY, FWD	JCA-M47-1-03
<del></del>	<u> </u>	D3999-1	BAFFLE	
	1	D3999-3	BAFFLE	
2	2	D3999-5	ANGLE	
12	12	MS20470AD4	RIVET	
	1 2	-041 -043 X X 1 1 2 2	-041 -043 PART NUMBER  X D3999-041  X D3999-043  1 D3999-1  1 D3999-3  2 D3999-5	-041



D3999-041 BAFFLE ASSEMBLY, AFT

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3999-041/-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT (-041): 1.51 bs
8) WEIGHT (-043): 1.84 bs

#### D3999-043 BAFFLE ASSEMBLY, FWD

RELEASED DA

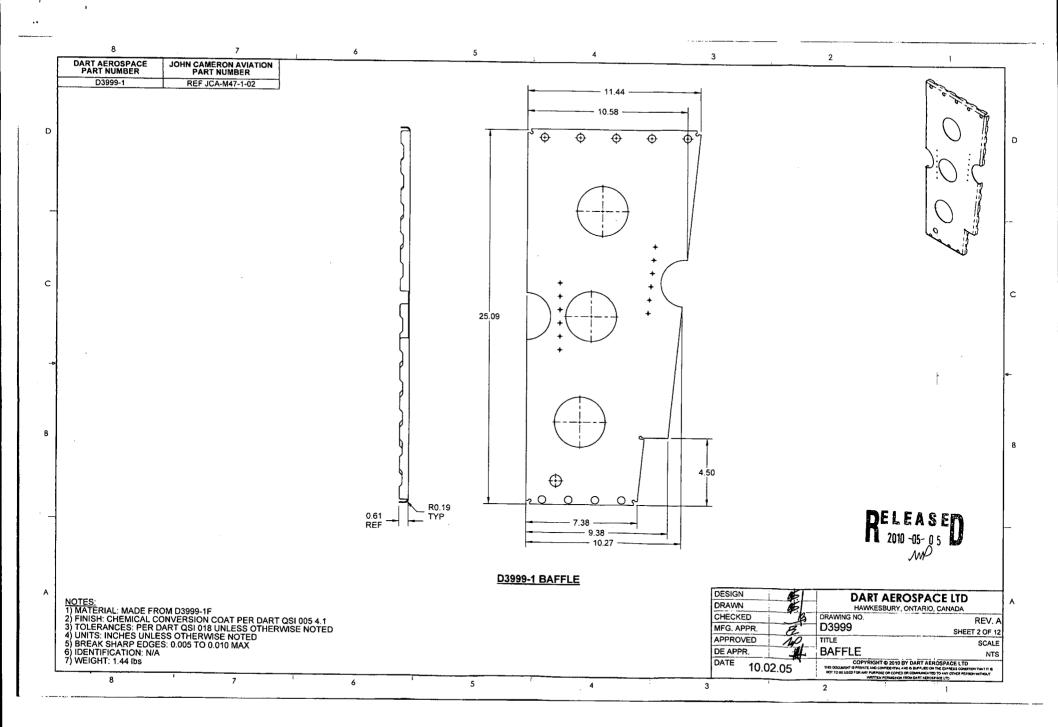
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REV.			DESCRIPTION	BY	DATE
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CHECKE MFG. AF		B	DRAWING NO. D3999		REV. A
APPROV		14	BAFFLE		SCALE
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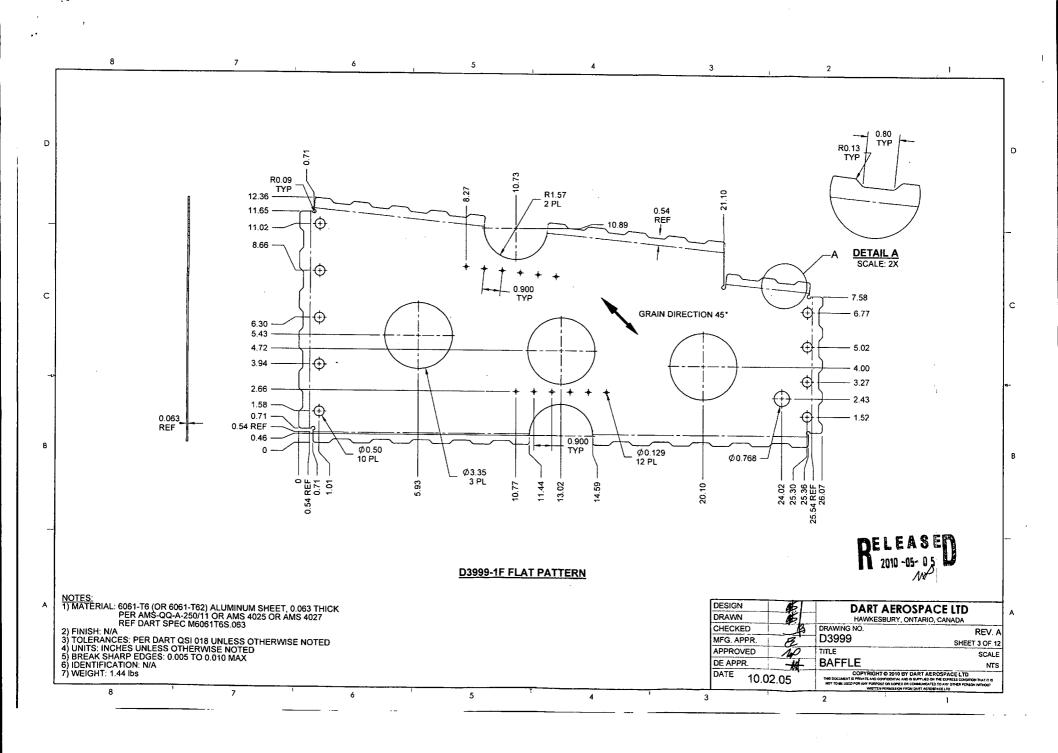
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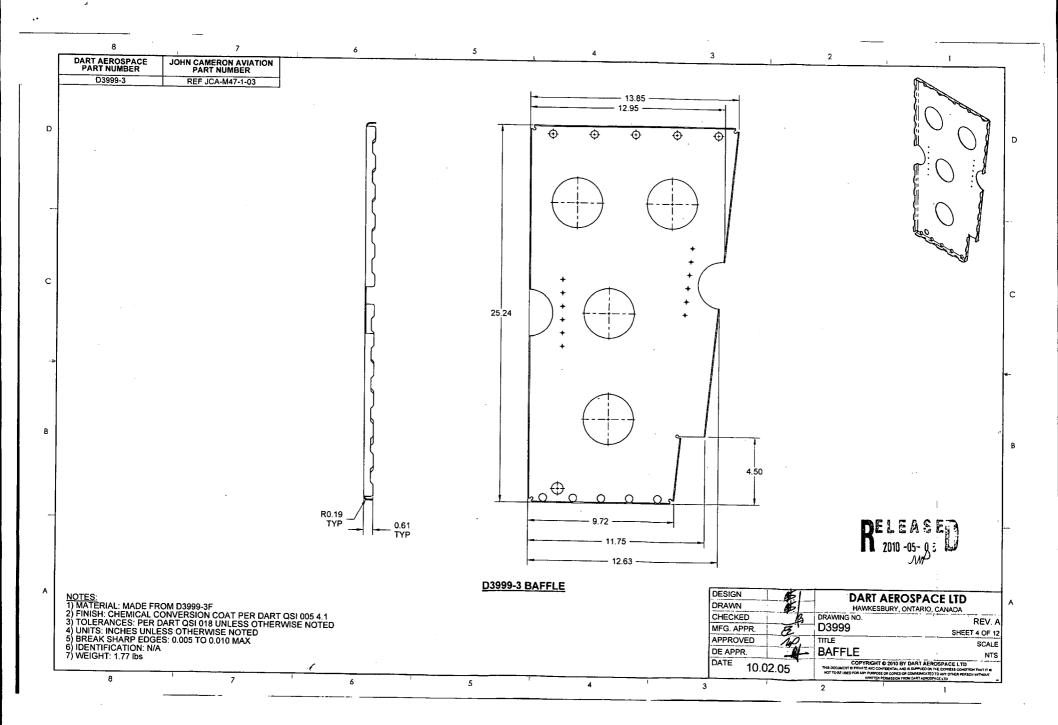
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		Section A	Chief Eng	Chief Eng	puon	Date	Section	IC	Chief Eng	QC Inspecto

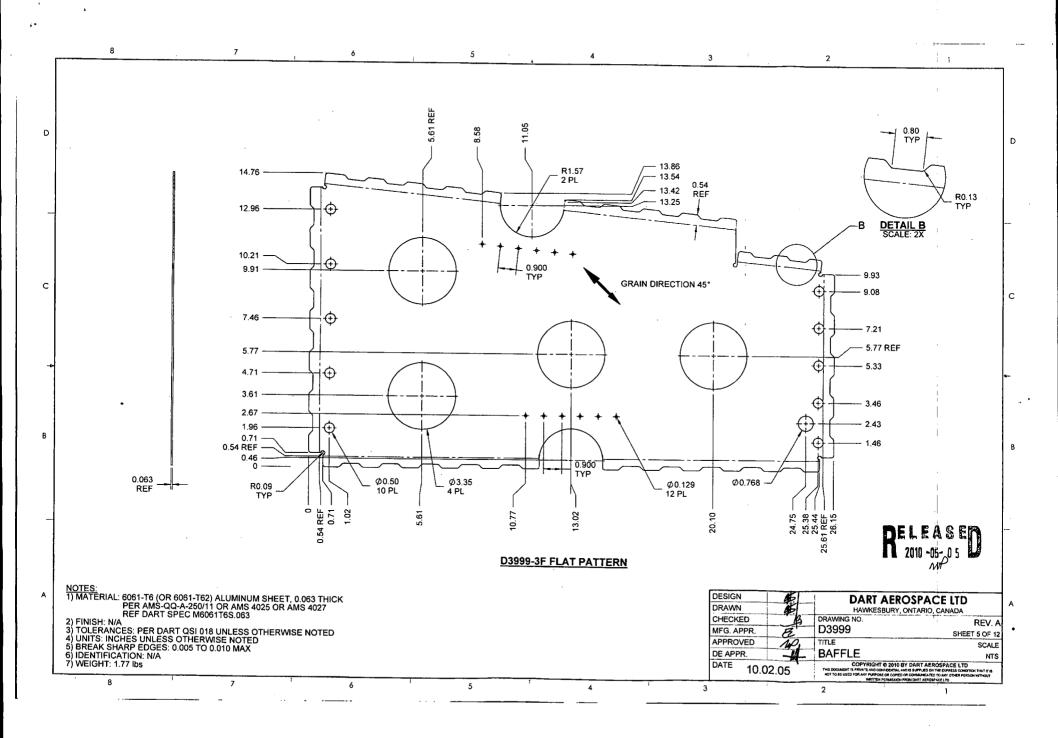


#### **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES Approval Approval** DATE STEP PROCEDURE CHANGE By Qtv Chief Eng / Prod Mgr Date QC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_ Resolution: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & Initial **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng



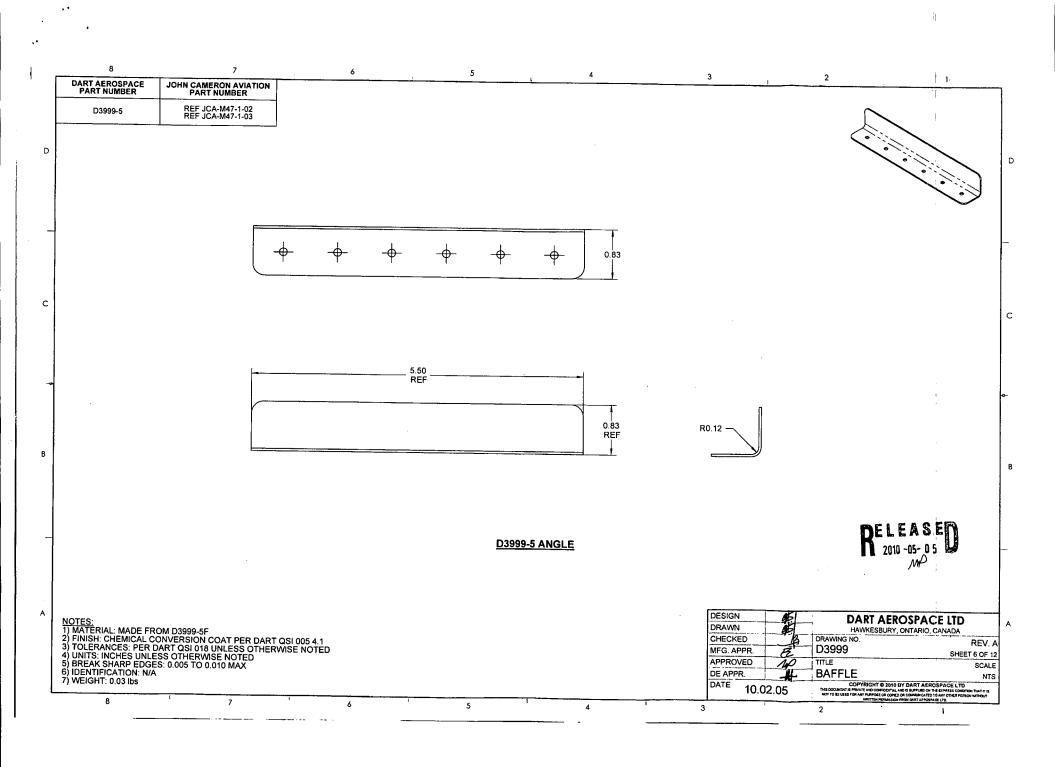
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	Approval C Inspector



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		Description of NC		Verification	A	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

R0.20 TYP BEND LINE-GRAIN DIRECTION 1.55 0.78 REF 0.40 TYP 0.50 TYP 0.040 REF Ø0.129 6 PL 0.900 TYP

**D3999-5F FLAT PATTERN** 

С

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.040 REF DART SPEC MOUNT 105.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

8

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DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 7 OF 12 APPROVED TITLE SCALE DE APPR. **BAFFLE** NTS DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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# **Dart Aerospace Ltd** W/O: **WORK ORDER CHANGES** Approval Chief Eng / Prod Mgr Approval DATE STEP PROCEDURE CHANGE Bv Date Qtv QC Inspector Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_\_ Resolution: QA: N/C Closed: Date: \_\_\_\_\_ WORK ORDER NON-CONFORMANCE (NCR) NCR:

DATE		Description of NC		Verifica	lion	A 1	Annuarial		
	STEP	TEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approval QC Inspector

2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-7 JCA-M47-1-17 D 0 - 0.59 0.59 С 1.77 Ø0.157 0.080 REF **D3999-7 CORNER** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.080 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 8 OF 12 APPROVED TITLE SCALE 6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs BAFFLE DE APPR. SAFFLE

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W/O:		WORK ORDER CHANGES									1
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Part No		PAR #:									
	R	esolution:								Date:	
NCR:		V	VORK ORE	DER NON-C	ONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Se Initial Action Description Chief Eng Chief Eng			Sign & Date		Verifica Section		Approval Chief Eng	Approval QC Inspector
				- Abanda							
									•		

5 3 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-9 JCA-M47-1-18 D D 1.38 REF С 1.38 REF R0.19 1.38 REF D3999-9 ANGLE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA NOTES:
1) MATERIAL: MADE FROM D3999-9F
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs DRAWN DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 9 OF 12 APPROVED TITLE SCALE **BAFFLE** DE APPR. NTS THE COPYRIGHT © 2010 BY DART AEROSPACE LTD

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DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approv QC Inspect	
Part No	Part No: PAR #: _		Fault Category: NCR: Yes No DQA:						Date:		
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DATE	CTED	Description of NC				ection B Veri			Approval	Annroys	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion	Sign 8 Date	Verification Section C	c	Chief Eng		

Ø0.768 С GRAIN DIRECTION £ 1.38 BEND LINE 0.68 0.063 REF 1.29 REF D3999-9F FLAT PATTERN NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S0.063 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.02 lbs CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 10 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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DATE	STEP	PRO	PROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:							
NCR:		<u> </u>		DER NON-CONFORMA			<u> </u>		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sigr			Approval Chief Eng	Approval QC Inspector
		,							

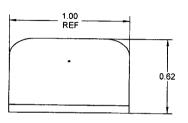
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-11 JCA-M47-1-19

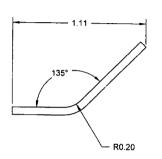
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#### **D3999-11 EARTH TAB**

NOTES: 1) MATERIAL: MADE FROM D3999-11F 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
CONTRACTOR AND

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6) IDENTIFICATION: N/A 7) WEIGHT: 0.01 lbs 8

DESIGN DRAWN DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 11 OF 12 APPROVED TITLE SCALE DE APPR. **BAFFLE** NTS COPYRIGHT © 2010 BY DART AEROSPÄCE LTD

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## **Dart Aerospace Ltd**

W/O:				<b>.</b>		<u> </u>			
DATE	STEP	PRO	WORK ORDER CHANGES PROCEDURE CHANGE  By Date			Approval Chief Eng / Prod Mgr			
		·							
		PAR #:							
	R	lesolution:						Date:	
NCR:		V	WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sigr	Verifica Section		Approval Chief Eng	Approval QC Inspector
		·							

1.32 — Ø0.125 2 PL 0.56 1.00 GRAIN DIRECTION 0.22 TYP R0.20 TYP 0.25 0.063 REF 0.52 REF BEND LINE

**D3999-11F FLAT PATTERN** 

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063 2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NIA
7) WEIGHT: 0.01 lbs

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 12 OF 12 APPROVED TITLE SCALE DE APPR. **BAFFLE** NTS THE COPYRIGHT © 2010 BY DART A EROSPACE LTD
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W/O:		WORK ORDER CHANGES						1		
DATE	STEP	PROCEDURE CHANGE By Date C					dty	Approval QC Inspector		
		·								
										·
Part No	:	PAR #:	Fault Cat	Fault Category: No			NCR: Yes No DQA:			
	R	esolution:	Dispositi	on: <u>/</u>	QA	: N/C Clo	sed:	Date:		
NCR:			WORK ORE	DER NON-CONFO	RMANCE	(NCR)	,	; .		
DATE	STEP	Description of NC		Corrective Action	Section B		Verificat	on	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Descrip	otion 	Sign & Date	Section		Chief Eng	QC Inspector
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